LBP-PT031
(20 031 kw)

ABSTRACT

A method and a device for the longitudinal welding of profiles (2,5, 13) is provided in which a profile (13) that is to be provided with a weld seam (22, 23) is guided through a welding device (1), and in the welding device (1) a welding head (14, 15) produces a weld point (20, 21) on the profile (13), in order to manufacture a weld seam (22, 23). The profile movement is braked at selectable intervals from an essentially constant production speed down to the point at which the profile (13) is at a standstill, and is subsequently accelerated back to the production speed, while the application of welding energy to the profile (13) is switched off below a threshold transport speed. In order to avoid a gap in the resulting weld seam (22, 23), according to the present invention a welding head control system is used, with the aid of which the location of the weld point (20, 21) is moved in the direction of transport (12) of the profile (13), beginning from an initial point, each time the profile (13) is at a standstill, the weld point (20, 21) being moved back to the initial position, against the direction of transport (12) upon restarting of the transport movement after the threshold transport speed has been reached.